

Work Order ID 166315

Friday, September 15, 2017 8:48:38 AM

166315

Ship Oct 13

Page 1

Item ID: D5951 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle
 Start Date: 9/15/2017 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 9/26/2017 Req'd Qty: 2.00 *2* Customer:
 Reference: SEP 15 2017

Approvals: Process Plan: DAS Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5951	Rev B

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per folio D5951, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble

1.70

1.78

2 0 art/SBL 17/09/27

110

110

QC

Quality Control

QC1- Inspection performed by CMM

QC2

Memo

0.00

0.00

2 0 art/SBL 17/09/27

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.04

S.A 17-09-27

2 0 DAS 08 9-89

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Friday, September 15, 2017 8:48:38 AM

166315

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 57399	0.00				2	SEP 27 2017		rd
160									
Packaging	Memo	0.02							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.20							
Quality Control									

DAS 6 9-89

17/9/27

um 17/9/27.

Picklist Print

Friday, September 15, 2017 8:48:42 AM

Page 1

Work Order ID: 166315

166315

Parent Item: D5951

D5951

Parent Item Name: Saddle

Start Date: 9/15/2017

Required Date: 9/26/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:E Re-Format 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-013		Manufactured	No			100	Each	14.0000	1	2			
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D6101-013

Saddle Billet

DAS
49
9-89

Location

MAT044

148161

165289

Loc Qty

14

8

6

Loc Code

2

17/09/25

DART AEROSPACE LTD		Work Order: 166315
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		1.438	1.438				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		1.318	1.318				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		1.316	1.316				
L	0.495	0.505		1.500	1.500				
M	0.490	0.510		1.508	1.506				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		8.004	8.004				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		1.311	1.311				
R	0.760	0.765		1.765	1.765				
S	0.490	0.510		1.500	1.500				
T	1.375	1.395		1.380	1.380				
U	2.000	2.020		2.000	2.000				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

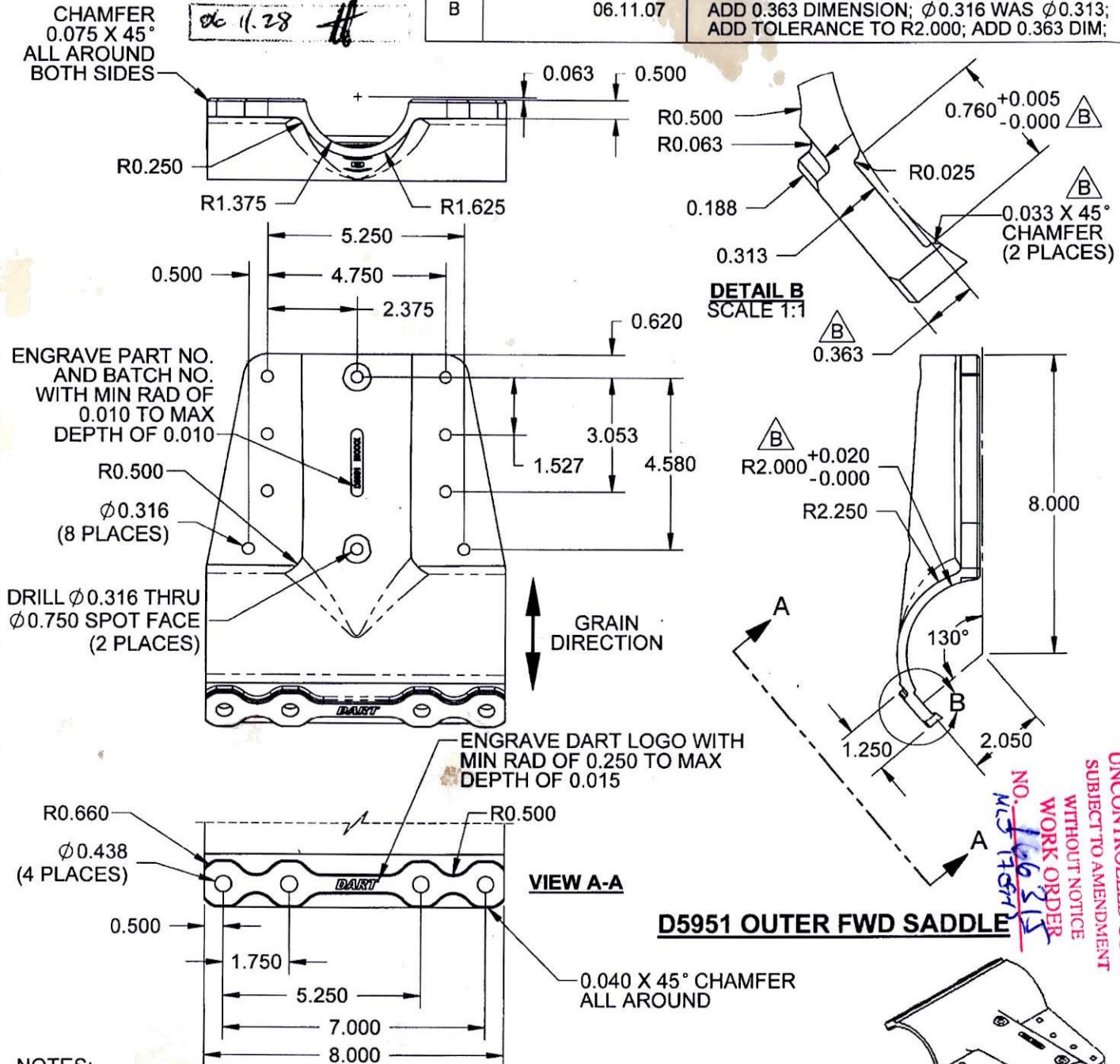
Measured by: SBL/ank
Date: 17/09/27

Audited by: A.E.	DAS
Date: 17-09-27	08 9-09

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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